

Date: Wednesday, 2/20/2008 4:27:33 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET LID ASSEMBLY		
Job Number	: 37560A					
Estimate Number	: 10853					
P.O. Number	:			Part Number	: D3325041	
This Issue	: 2/20/2008		S.O. No. :	Drawing Number	: D3325 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	: 37495A			Material	:	
Written By	:			Due Date	: 3/30/2008	
Checked & Approved By	:			Qty:	1 Um: Each	
Comment	: Est Rev/A 05.02.09 New issue KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33281	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2 D3328-1	Hinge Plate	<u>B34123</u> ✓
2.0	D33491	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2 D3349-1	Spacer Bushing	<u>B34205</u> ✓
3.0	D33521	Label Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2 D3352-1	Label Plate	<u>B34206</u> ✓
4.0	D33671	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description	
	2 D3367-1	Mounting Bracket	<u>B36179</u> ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:27:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 37560A

Part Number: D3325041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M4130NTS0500W035 4130 Square tube .5 x .5



Comment: Qty.: 21.5687 f(s)/Unit Total : 21.5687 f(s)

Material: 4130 Cond. N Square tube per MIL-T-6736,

✓ 1/2" x 0.035" wall

M4130N-TS0.500W.035)

SAD 08/04/29 ①

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
2	D3325-1	EndTube	<u>M107848</u>
3	D3325-3	Interior Tube	<u>M107848</u>
2	D3325-5	Full Length Tube	<u>M107848</u>

Identify parts appropriately

2-Remove all markings from material

SAD 08/04/29 ①

3-Drill and Weld as per Dwg D3325 & QSI 004

AVRN/Steel Rod M100075

4-Deburr as required

Fl 08/04/30

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-30 ①

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-04-30 ①

13375604

D 332504

30/04/2008

S.159 11.07

#1 399.6 F

#2 --- F

#3 30 MINS. F

#4 --- F

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3



M107550

11 08-04-30 ①

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(1X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M/p 08/04/30

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

37560

12.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/30 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



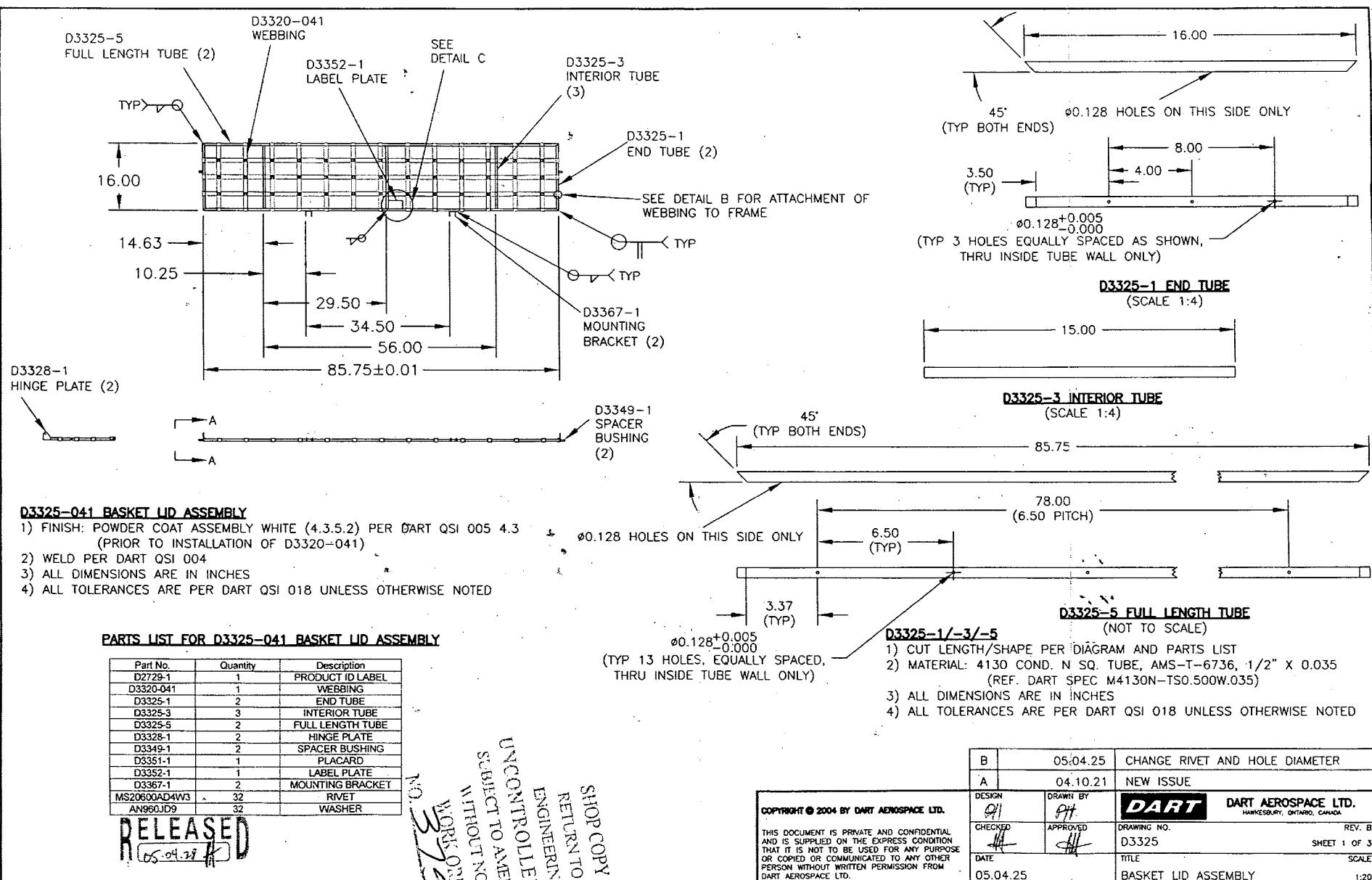
✓ 08.04.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



AN960JD9 32
RELEASED
05-04-28

37560

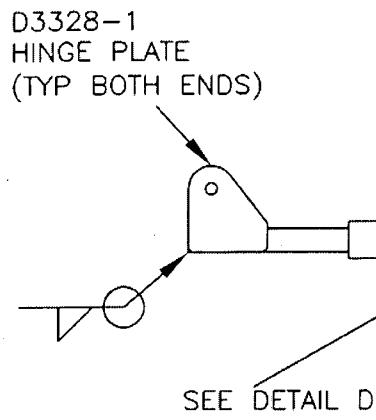
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING COPY
RETURN TO
SHOP COPY

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B	05.04.25	CHANGE RIVET AND HOLE DIAMETER		
A	04.10.21	NEW ISSUE		
DESIGN <i>91</i>	DRAWN BY <i>JH</i>	DART		DART AEROSPACE LTD. HAWKSBURY, ONTARIO, CANADA
CHECKED <i> </i>	APPROVED <i> </i>	DRAWING NO. D3325	REV. B SHEET 1 OF 3	
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:20	



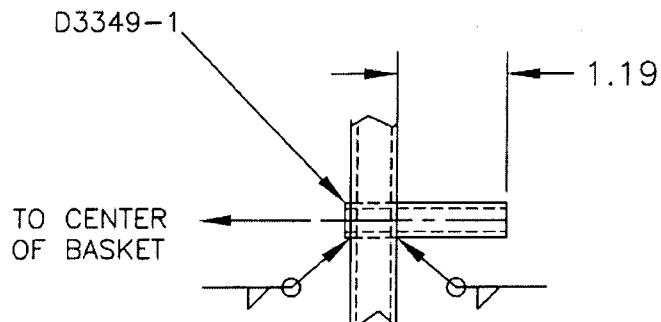
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CHECKED <i>ff</i>	APPROVED <i>ff</i>	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



D3367-1
(REF)

DRILL $\phi 0.375$ FOR
INSTALLATION OF
D3349-1 SPACER
BUSHING BOTH ENDS

VIEW A-A



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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37560

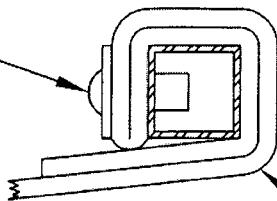
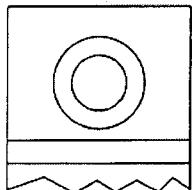
DETAIL D
(SCALE 1:2)

RELEASED
05.04.28



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)

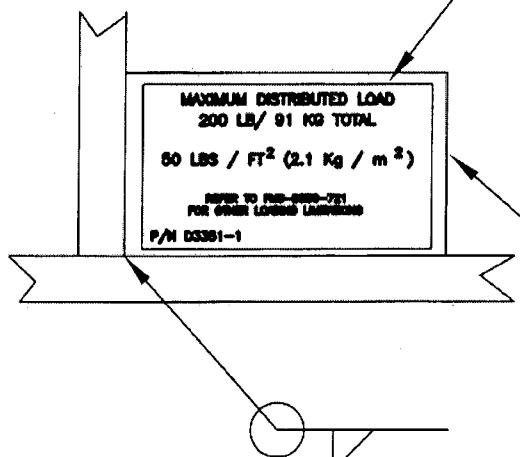


DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

D3320-041 WEBBING

RELEASED
05.04.28 *PH*

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



D3352-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
37560

OUTBOARD

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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